

Date: Monday, 22/09/2008 1:03:38 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 42175		Part Number	: D28063		
Estimate Number	: 10518		Drawing Number	: D2806 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 22/09/2008	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 29/09/2008	Qty:	50
Previous Run	: 39058		Um:	Each		
Written By	:					
Checked & Approved By	: JUL 08.9.22					
Comment	: Est:B 05.03.11 Part now turned KJ/JLM Est Rev:C Now on Doosan Lathe JLM Verified By:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6H1000	6061-T6 HexBar 1.00
Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s) 6061-T6 Hex Bar 1.0" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar (M6061T6H1.000) Batch: M109478 SA 08/11/11		
2.0	DOOSAN LATHE	DOOSAN LATHE
Comment: Doosan Lathe 1- Turn as per Folio FA105 Rev: A & Dwg D2806 Rev: A 2-Deburr per dwg D2806 SA 08/11/11		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SA 08/11/11		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK JL 08/11/11		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 M-J 08/11/12		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



LL



K50

Comment: INSPECT ALODINE

08-11-12

7.0 PACKAGING 1

PACKAGING RESOURCE #1



SOX

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *48*

6/11/12

SO

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42175
Description: Bushing	Part Number:	D2806-3
Inspection Dwg: D2806 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SJ</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	08/11/11	Date:	08/11/11	Date:	N/A

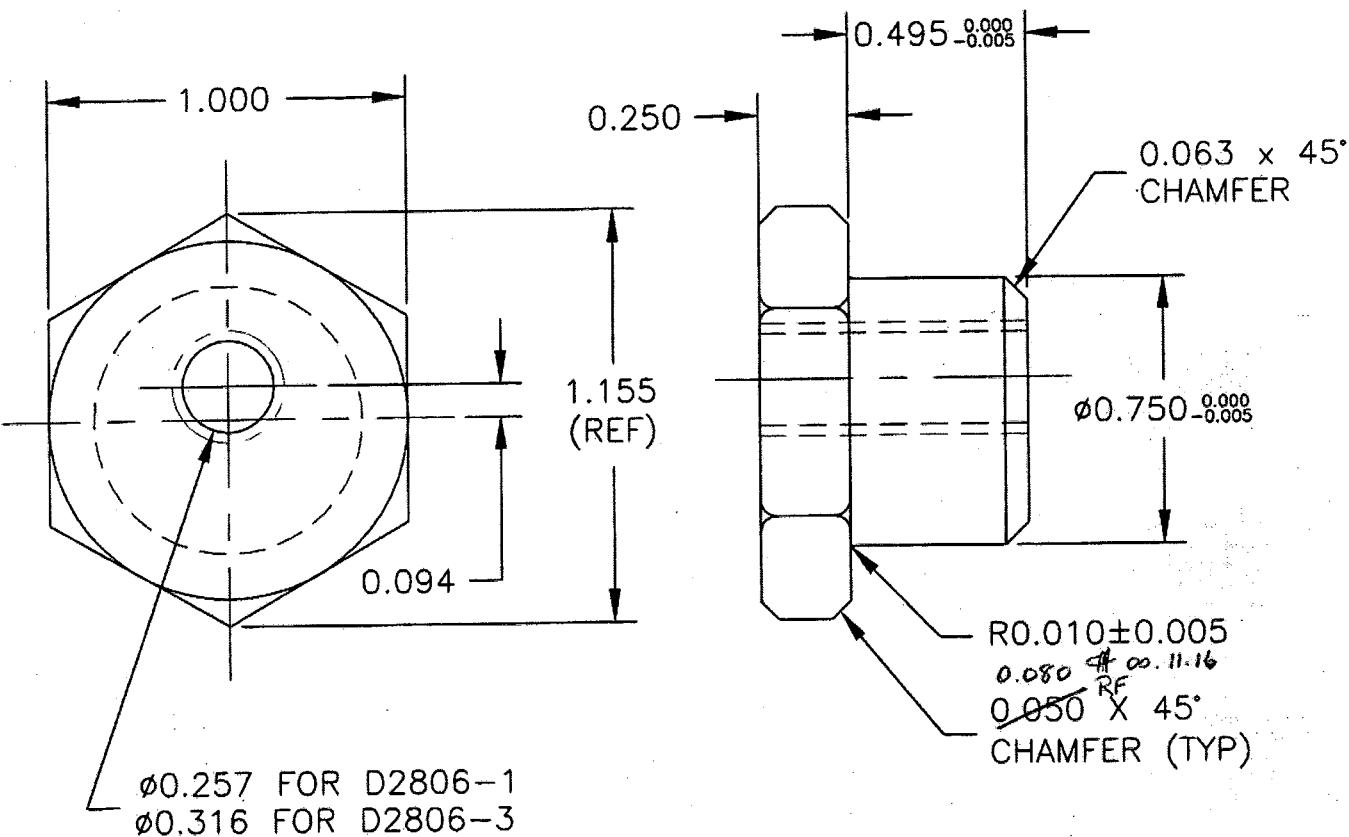
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2806	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.08		BUSHING	2:1
A	00.11.08	NEW ISSUE	

RELEASED

00.11.13



D2806-1 (DRILL Ø0.257 HOLE)
D2806-3 (DRILL Ø0.316 HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-257/11)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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